



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

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601.3902
Job Sheet 181435



Part No: 601.3902

Job Qty: 30 ea

Part Name: Eye Bolt



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/C IPP REV:A NEW ISSUE 16-03-07 JLM VERIFIED BY:JFS

Ship Via:

11.5A

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	9/10/18	9/10/18	0.00	0.00	Start Up Machining-1		
100	Doosan	30 pcs	9/10/18	9/10/18	0.56	16.91	Doosan		
110	QC	30 pcs	9/10/18	9/10/18	0.00	0.00	QC2 Machining-1		
120	QC	30 pcs	9/10/18	9/10/18	0.00	0.00	QC8 Machining-1		
130	Packaging	30 pcs	9/10/18	9/10/18	0.00	0.00	Packaging3-1		
140	QC21-SA	30 Ea	9/10/18	9/10/18	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Folio FB466 Dwg 601.3902 Folio Rev: ____ Dwg Rev: ____ 2-Deburr
Descriptions: 140 - Identify as MPP-120

OCT 04 2018
OCT 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M316R1.000	316 Round Bar 1.00	4.2000 ft (.14 ea)	90-Start up Operation	

5099810

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M316R1.000	4	1	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eye Bolt	0.310Inches ± 0.010	0.320 0.300	Radius	
2	Eye Bolt	0.620Inches ± 0.010	0.630 0.610		
3	Eye Bolt	0.470Inches ± 0.010	0.480 0.460		
4	Eye Bolt	0.400Inches ± 0.010	0.410 0.390		
5	Eye Bolt	0.220Inches ± 0.010	0.230 0.210		
6	Eye Bolt	0.150Inches ± 0.010	0.160 0.140		
7	Eye Bolt	1.310Inches ± 0.010	1.320		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

			1.300	
8	Eye Bolt	0.250Inches + 0.005 - 0.001	0.255 0.249	Diameter
9	Eye Bolt	1.270Inches ± 0.010	1.280 1.260	
10	Eye Bolt	0.830Inches ± 0.010	0.840 0.820	
11	Eye Bolt	0.730Inches ± 0.010	0.740 0.720	
12	Eye Bolt	0.530Inches ± 0.010	0.540 0.520	
13	Eye Bolt	0.320Inches ± 0.010	0.330 0.310	

Plex 7/26/18 8:42 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION ☐ Rewo ☐ Scr ☐ Use-as- ☐ Suspected Unapprove
Part No. _____	
NCR No. _____	

Date : _____	Step #: _____
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Description Work Order Deviation

Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: _____
 Part: 601.3902
 Job No: 181435
 Serial No/Batch: S114848

Date: 10/01/8

DART
 AEROSPACE
 Container No: S114848
 Part: 601.3902
 Job No: 181435
 Serial No/Batch: S114848
 Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
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 Email: sales@dartaero.com
 www.dartaerospace.com

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				